October-19-12 2:44:25 PM

Item ID: 646.9501 Accept *N900040100* Setup Start **Revision ID:** Item Name: 206 Cable Cutter, High Start Otv: 1.00 Start Date: 19/10/2012 Cust Item ID: **Required Date:** 02/11/2012 **Reg'd Oty:** 1.00 **Customer:** Reference: Run Process Plan: MU5 Date: 12-10-19 Tooling: Approvals: Date: Stop QC: ____ Date: SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Qty Code **Qty** Number Stamp **Draw Nbr Revision Nbr** 646,9500 N/C 100 0.00 DAS DOCUMENT CONTROL *100* MLT 27 DC 9-89 0.00 Memo BODY Document Control Photocopy bluefile & type labels per PPP 646.9501 110 Pick Kit 0.00 *110* Packaging 0.00 Memo Packaging 120 QC4- 100% Inspect kits for completeness 0.00 DAS 27 *120* 9-89 ОC 0.00 Memo 13.10.24 Quality Control

NCR:	yes	/ No				WORK ORDER NON-	JU.	ALOKI	VIANCE / UP	DATE			
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	,					Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	ı	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Other	Н												
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Supplier Training	Н						-						
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Landi	ng G	Gear				General		CATE					
		Bending				Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	П	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	-	Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved	_	
		Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	
	Inspection Strip in Tube					Cut Too Short		Misread	l		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
	Ш	Torque W	aves in E	xtrusio	ո 🗀	Drawing		Out of 0	Calibration				
	Turning Sequence					Finish		Out of S	iequence				

Outside Dimensions

DQA:

Date: •

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 2:44:25 PM

Item ID: Revision ID:	646.9501			Accept	*N900	040	100) * s	Setup Stai	*N	S1*
Item Name:	206 Cable Cu	tter, High							Sto	P *N	S2*
Start Date:	19/10/2012	Start Qty: 1.00	*1*		Cust Item	ID:					() /
Required Date:	02/11/2012	Req'd Qty: 1.00	*1*		Customer:						
Reference:			·								
Approvals:	Process Pla	n:	Date:	Tooling:	D	ate:		F	Run Star	171	R1*
	QC:		Date:	SPC (Y/N):		ate:			Stoj	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130 *130*		Packaging		0.00		DAS 6		(3)10	124		
Packaging		Memo		0.00		9-89		10(19	101		
Packaging		Identify and Location.	pack for shipping as per	PPP 646.9501						•	
140		QC21- Final Inspection -	Work Order Release	0.00							14
140		Memo		0.00	·			MU	Z (3-14	E
Quality Control										1	Ц

N13-10-24

										DQA:	Date: _	•
NCR: Y	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE										Data	ويوفيد
							-			QA Closed:	Date:	
Work Orde	er:				DIS	SPOSITION			AGAINST DE	PARTMENT	PROCESS	
	-	' ' ' -				Rework		Skid-tube	Crosstube		Water Jet 📗	Engineering
Part N	۱o					Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	Thern	noforming	Other			
NCR N	۱o				Work (Order Update						
				,								
Root					Description of work		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	or Non-confo	rmance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator	\Box											
Material												
Setup				,								
Other												
Process												
Supplier												
Training												
Unapproved												
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nain	g Gear,	General				
	Bending	Bend	Grain	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance		Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect		Weld
L	Crushed/Crimped_	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled
L	Cuffs	Contamination	Maintenance	Part Moved	·	_
	Heat Treat	Countersink	Mislabeled	Positioned Wrong		_
Ĺ	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge		Other
L	Ripples in Bend	Drill Holes	Offset			
	Torque Waves in Extrusion	Drawing	Out of Calibration			
	Turning Sequence	Finish	Out of Sequence			
	Wave/Twist in Tube	Folio	Outside Dimensions			

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Picklist Print

October-19-12 2:44:29 PM

Work Order ID: 92040

92040

Parent Item:

646.9501

646 9501

Parent Item Name: 206 Cable Cutter, High

Start Date: 19/10/2012

Required Date: 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 12.08.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Stati
*646.9601 *646.9601- Upper Cutter Assembly	DAS 27 9-89	Manufactured	No	<u>-</u> .		110	Each	0.0000	**	1 912	83 JB	DAS
*646.9602 *646 9602 Lower Cutter Assembly, Hig	DAS 27	Manufactured	No			110	Each	0.0000	**	1 897	05 gB	9-89 DA6
*646.9810 *646.9810 Deflector	DAS	Manufactured	No			110	Each	0.0000	**	1644 1644	45 J	989 988)
*647.0210 *647	27 9-89 * DAS 27	Manufactured	No			110	Each	0.0000	**	1 91440	- } 2B	31/ 9-69 DAS /31/
*647.0110 *647.0110 Roof Doubler	9-89 * DAS 27 9-89	Manufactured	No			110	Each	0.0000	**/	1.	- 49 <i>zs</i>	9.69 DAS
47.0310 *647 0310 Channel	. DAS	Manufactured	No		·	110	Each	0.0000	**	2 905 (52 g g	9-89 DAS
46.9910 46.9910 trut	* DAS 27 9-89	Manufactured	No			110	Each	0.0000	** 37	4 1042	9 10	989 DA
*647 01-1-2 Strut Bracket	yDAS 27 9-89	Manufactured	No			110	Each	0.0000	** 3×	919:	, , ,	989 3-09-0 DAS

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	//ANCE / UPI	DATE					
											QA Closed:	Date:			
Work Ord	er:					DISPOSITION	,		F	AGAINST DE	PARTMENT	_			
Part NCR						Rework Skid-tube Machining Use-as-is Thermoforming Large Fab				Crosstube Small Fab Finishing Composite	Fab Prod. Eng. Coor. Quality Shing Rec/Store/Packaging Other				
Root			<u></u>	0.		ption of work order update		Initial		tion	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descr	ription	Date	Verification	QC Inspector		
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Setup Other	-														
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Landi	ng (Gear `				General									
	:	Bending				Bend		Grain			Ovalized		Pressure/Forced		
	,	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld		
	Crushed/Crimped.					Burrs		Instruct	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
		Cuffs				Contamination		Mainte	nance		Part Moved				
	Heat Treat					Countersink		Mislabe	led		Positioned V	Vrong	_		
	Inspection Strip in Tube					Cut Too Short			Misread			Surge	Other		
		Ripples in	Bend			Drill Holes Offset									
	L_	Torque W	/aves in E	xtrusio	n 「	Drawing		Out of C	Calibration						

Out of Sequence

Outside Dimensions

DQA:

Date: °

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 2:44:29 PM

Work Order ID: 92040 *92040* Parent Item: 646.9501 *646 9501* Parent Item Name: 206 Cable Cutter, High Required Date: 02/11/2012 Start Date: 19/10/2012 Required Qty: 1.00 Start Oty:, 1.00 647.0113 DAS Manufactured No 110 Each 0.0000 27 9-89 Strut Doubler 647.0111 Manufactured No 110 0.0000 Each ** DAS 89763 [']Panel 27 647.0116 9-89 Manufactured No 110 Each 0.0000 DAS ** 89699 27 Doubler 9-89 647.0410 Manufactured No 110 0.0000 Each DAS ** 27 Tube 9-89 647.0114 Manufactured No 110 0.0000 Each DAS ** DAS 89759 27 -33 Clip 9-89 9-89 647.0115 Manufactured No 110 0.0000 Each DAS ** 27 DAS 10539 Člip 9-89 33 NAS1149FN832P 9-89 Purchased No 110 Each 523.0000 149FN832P* ** 123900 20 Washer DAS 27 Location Loc Qty Loc Code 9-89 275 198 122441 198 ST275 125 115158 125 ST294 200 123352 200

												DQA:	Da	ite:	•
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	DATE					
											_	QA Closed:	Da	ite:	
Work Ord	or.					DISPOSITION				AGAINST D	EF	PARTMENT	/PROCESS		
i i i i i i i i i i i i i i i i i i i	. .					Rework	ا ٦		Skid-tube	Crosstube	٦		Water Jet		Engineering
Part I	No.					Scrap]	Machining Small Fab]	Pro	d. Eng. Coor.		Quality
						Use-as-is		Therm	noforming	Finishing	Rec/Store/Packagin			\blacksquare	Other
NCR I	Vo.					Work Order Update	┛		Large Fab	Composite	╛		Supplier	L	
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Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descri	iption		Date	Verification	'n	QC Inspector
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	L	Bending				Bend		Grain		L	╝	Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance	L	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/U	Inclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination] Mainte	nance	Γ	1	Part Moved			-
		Heat Trea	it			Countersink		Mislabe	eled		Positioned Wrong				
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i			Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Picklist Print

October-19-12 2:44:29 PM

Work Order ID: 92040 *92040* 646.9501 Parent Item: *646 9501* Parent Item Name: 206 Cable Cutter, High **Required Date: 02/11/2012 Start Date: 19/10/2012** Start Qty: 1.00 Required Qty: 1.00 NAS1149F0332P Purchased 110 No Each 1,274.000 123900 70 Location Loc Qty Loc Code 275 298 DAS 122441 298 ST275 776 117735 13 119225 8 121259 138 121825 14 122063 600 17317 3 ST295 200 123352 200 AN3-11A Purchased 110 No Each 346.0000 123759 JB Location Loc Oty Loc Code DAS ST351 346 27 110865 46 9-89 115457 100 123352 200 MS21042-3 Purchased No 110 Each 17 123525 Location Loc Qty Loc Code DAS ST315 500 27 123352 500 9.89

NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UPI	DATE			
											QA Closed:	Date	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	,
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		I Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Rec/Sto	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
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		Centre No	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa	ıre		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld
	L	Crushed/	Crimped.			Burrs		Instruct	tions Incomplete/l	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	ıt			Countersink		Mislabe	eled		Positioned V	Vrong _	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	Ė		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	/aves in E	xtrusio	n [Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 2:44:29 PM

Work Order ID: 92040 *92040* Parent Item: 646.9501 *646 9501* Parent Item Name: 206 Cable Cutter, High **Start Date:** 19/10/2012 **Required Date: 02/11/2012** Required Qty: 1.00 Start Otv: 1.00 CCR264SS-3-06 Purchased No 110 Each Location Loc Qty Loc Code 27 9-89 ST327 100 123023 100 MS21059L08 Purchased No 110 Each 1,282.000 Location Loc Qty Loc Code ST300 112314 7 DAS 27 ST314 400 123265 400 ST316 875 123100 775 123352 100 CR3213-4-05 Purchased -No 110 Each 738.0000 cherry rivet Location Loc Qty Loc Code ST328 DAS 600 123301 27 123301 600 9-89 ST331 138 108473 38 108991 100

											DQA:	Dat	e:	•
NCR:	⁄es	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UPD	ATE				
											QA Closed	: Dat	te:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part I	No.					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other	
Root					Descri	ption of work order update		Initial	Actio	on	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	า	QC Inspector
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		Cracks				Broken/Damaged		Inspecti	on Incomplete	Г	Part Incorre	ect		Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/Ui	nclear	Part Lost/M	lissing		Wrong Stock Pulled
Cuffs Contamination					Contamination	Maintenance Part Moved				·				
:		Heat Trea	t			Countersink	Mislabeled				Positioned Wrong			
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss	/Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

October-19-12 2:44:29 PM

Work Order ID: 92040 *92040* 646.9501 Parent Item: *646 9501* Parent Item Name: 206 Cable Cutter, High **Required Date:** 02/11/2012 **Start Date:** 19/10/2012 Start Qty: 1.00 Required Qty: 1.00 CR3213-4-6 Purchased No 110 Each 400.0000 20 Location Loc Oty Loc Code ST329 400 123301 400 CR3213-4-4 Purchased No 110 410.0000 Each Location Loc Oty Loc Code DAS ST328 400 9.89 123301 400 ST331 10 104291 10 CR3213-4-2 110 Purchased No Each 18 Cherry Rivet Location Loc Oty Loc Code DAS ST328 1000 27

1000

19

19

9-89

October-19-12 2:44:29 PM

123301

113288

ST331

123301

												DQA:	Date	: <u> </u>
NCR:	Yes	/ No				1	WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE	·		
												QA Closed:	Date	:
Vork Ord	er.						DISPOSITION				AGAINST D	EPARTMENT/	PROCESS	
voik Old	C1.						Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	No.						Scrap			Machining	Small Fab	Proc	d. Eng. Coor.	Quality
							Use-as-is			noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR	No.						Work Order Update		٠	Large Fab	Composite		Supplier	
				,					Na Caraca Ca		T			
Root		D. 4	٥,	<u> </u>	1	-	on of work order update		nitial	Action g Description		Sign &	\	061
Cause		Date	Step	Qty		or N	Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
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quip/Tooling	\vdash													
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Landi		7			_	_	General		ì			_	_	_
		Bending			L	_	end		Grain		_	Ovalized		Pressure/Forced
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	Cracks					_	roken/Damaged			on Incomplete		Part Incorred	 	Weld
Crushed/Crimped_						⊣	ırrs		ĺ	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Cuffs							ontamination •	 	Mainte		_	Part Moved		
Heat Treat						→	ountersink		Mislabe	•	<u></u>	Positioned V	_	-
Inspection Strip in Tube							it Too Short		Misread	i	L	Power Loss/	Surge	Other
Ripples in Bend							rill Holes		Offset					
	<u> </u>	Torque W			n _	-1	rawing	Out of Calibration						
		Turning Se	-		<u>_</u>	-	nish	<u> </u>	1	equence				
		Wave/Twi	ist in Tub	oe .		Folio			Outside	Dimensions	•			

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Picklist Print

October-19-12 2:44:29 PM

Work Order ID: 92040 Parent Item:

CR3213-4-3

MS21047-3

646.9501

Parent Item Name: 206 Cable Cutter, High

Purchased

Purchased

Purchased

No

No

No

92040 *646 9501*

Start Date: 19/10/2012

Required Date: 02/11/2012

Start Qty: 1.00

1,050.000

Loc Code

Required Qty: 1.00 126320 28

DAS 27 9-89

Location Loc Qty ST328 1000 123301 1000 ST331 50 116583 6 118503 120910 10 121243 30 110 Each

110

Each

125,0000 125535 70

18

DAS 27 9.89

Location Loc Qty ST316 125 123268 50 123301 50 123352 25 110 Each

142.0000 123525 20

USE MS21042L08

DAS 27 9-89 Location Loc Qty ST300 42 103668 42 ST316 100 123352 100

Loc Code

Loc Code

DAS

NCR:	$oldsymbol{\cdot}$													
											QA Closed:	Dat	te:	
Work Ord	er:					DISPOSITION	_		F	_	EPARTMENT,			
Part I				•						Crosstube Small Fab Finishing Composite	⊣	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	ion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			-											
Landi	na (General	-AUI	T CATE	GORY					
Bending Centre Not Concentric to O/S BOM/Route						Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/U enance eled	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	T W W W W W W W W W	ressure/Forced emperature/Cure /eld /rong Stock Pulled
1		Liordae M	aves III E	.xu usior	' I	Intaming	1	Jour or (Landi atioff					

Out of Sequence

Outside Dimensions

Date: ____

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 2:44:29 PM

Work Order ID: 92040

Parent Item:

646.9501

Parent Item Name: 206 Cable Cutter, High

92040 *646 9501*

MS27039-08-13

Purchased

No

110

Each

392.0000

Loc Code

Start Oty: 1.00

Start Date: 19/10/2012

Required Date: 02/11/2012

Required Qty: 1.00

MS21059-3

Purchased

No

Location Loc Qty Mezz 4067 92 ST307 300 123352 300 110 Each

250.0000

123352

DAS 27 9-89

> Purchased No

Location Loc Qty ST316 250 123023 50 123301 200 110 Each

Loc Code

13-08-28

DAG 217 368**3** Location Loc Qty ST324 121825 8 ST347 10 123352 10 ST348 2 120242 2

Loc Code



DAS

											•	DQA:	Dat	te:	*
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		_		-	
										· · · · · · · · · · · · · · · · · · ·	Q	A Closed:	Dat	te:	
Work Ord	ar.					DISPOSITION				AGAINST D	EP#	RTMENT/	PROCESS		
WOIK OIG	Z1.					Rework	ا ٦		Skid-tube	Crosstube	7		Water Jet		Engineering
Part I	Nο		•			Scrap	-		Machining	Small Fab	-	Proc	I. Eng. Coor.	-	Quality
i uici	•0.	-				Use-as-is	┤		noforming	Finishing	1		e/Packaging	-	Other
NCR I	No.					Work Order Update	-	i e	Large Fab	Composite			Supplier		
						` <u> </u>	_ ;		• Ш	· L					
Root					Descr	iption of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling															
Operator															
Material											1				
Setup											1	·		-	
Other														1	
Process			1											ļ	
Supplier															
Training															
Unapproved							\perp								
							:AUI	T CATE	GORY						
Landi	ng (Gear			_	General	_	-			_				•
		Bending				Bend	L	Grain		L	_ c	valized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa	re		_]c	ver/Under	tolerance	<u>_</u>	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	ion Incomplete		P	art Incorred	:t		Weld
Crushed/Crimped. Burrs Instructions Incomplete/Unclear								'Unclear	P	art Lost/Mi	ssing		Wrong Stock Pulled		

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Required Date: 02/11/2012

Required Qty: 1.00

Picklist Print

October-19-12 2:44:29 PM

Work Order ID: 92040 Parent Item: 646.9501 *92040* *646 9501*

Location

Parent Item Name: 206 Cable Cutter, High

AN3-3A

Purchased

No

110

Each

Loc Qty

355.0000

Start Date: 19/10/2012

Start Oty 3.00

125709 78

DAS 27 9.89

DAS

27

9-89

CCR264SS3-04

Purchased

No

ST350 355 122416 55 122800 200 123352 100 110 Each

Loc Code

Loc Code

CR3212-5-4

Purchased

No

Location Loc Qty ST327 200 123352 200 ST331 446 17997 446 110 Each

Cherry Rivet

DAS 27 9-89

Location Loc Qty ST328 200 123301 200 ST330 168 120308 68 120410 100

Loc Code



DAS

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	100	NFOR	MANCE / UPD	DATE			
									<u> </u>		QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG	C1.					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	Nο					Scrap	1 1		Machining	Small Fab	Dro	d. Eng. Coor.	Quality
1 4101	10.					Use-as-is	1		noforming	Finishing	-1	re/Packaging	Other
NCR I	No.					Work Order Update	1	11.6111	Large Fab	Composite	11.00,310	Supplier	1 """
							ا ل	1			J		J
Root					Descri	ption of work order update	Π	Initial	Acti	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data	L												
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process					<u> </u>								
Supplier													
Training													
Unapproved													
	FAULT CATEGORY												
Landi	ng (Gear			,	General		,		ــــــــــــــــــــــــــــــــــــــ	-	_	-
	L	Bending				Bend	L	Grain			Ovalized		Pressure/Forced
	L	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Unde	r tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	on Incomplete		Part Incorre	ect	Weld
Crushed/Crimped. Burrs								Instruct	ions Incomplete/U	Inclear	Part Lost/N	lissing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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October-19-12 2:44:29 PM

Work Order ID: 92040

Parent Item:

CCR264SS3-2

NAS1835-08

646.9501

Parent Item Name: 206 Cable Cutter, High

92040 *646 9501*

No

Start Date: 19/10/2012

Required Date: 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

28

DAS

27 9-89

Purchased No

Purchased

Location Loc Qty ST331 154 106578 104 108738 2 112314 48 110 Each

110

Each

Loc Code 50.0000

154.0000

Insert

DAS 27

9.89

Purchased No Location Loc Qty ST298 50 123055 40 123078 10 110 Each

Loc Code 400.0000 **

123055

DAS 27 9.89 Location ST328

123301

Loc Qty 400 400

Loc Code

123301

DAS

											DQA	Date:		
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	MANCE / UP	DATE				
									· · ·		QA Closed	: Date:		
Work Ord	er.					DISPOSITION				AGAINST D	PARTMENT	PROCESS		
WORK ORG	C1.					Rework	7		Skid-tube	Crosstube	7	Water Jet	Engineering	
Part I	No.					Scrap	1		Machining	Small Fab	Pro	od. Eng. Coor.	Quality	
						Use-as-is	1	I .	noforming	Finishing		re/Packaging	Other	
NCR I	No.					Work Order Update	1		Large Fab	Composite	1	Supplier		
							_				-		· · · · · · · · · · · · · · · · · · ·	
Root		-			Descri	ption of work order update		Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data	L	ļ]											
Equip/Tooling	<u></u>													
Operator	L													
Material	L_												}	
Setup	L													
Other	<u>. </u>													
Process														
Supplier														
Training	┕												,	
Unapproved														
						· · · · · · · · · · · · · · · · · · ·	AUL	T CATE	GORY					
Landi	Landing Gear General													
		Bending				Bend		Grain		_	Ovalized		Pressure/Forced	
	Centre Not Concentric to O/S BOM/Route							Hardwa	re		Over/Unde	r tolerance	Temperature/Cure	
	\vdash	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ect	Weld	
	L	Crushed/	Crimped.			Burrs	Instructions Incomplete/Unclear				Part Lost/N	lissing	Wrong Stock Pulled	
		Cuffs				Contamination	Maintenance				Part Moved			
		Heat Trea	t		L	Countersink		Mislabe	led		Positioned	Wrong	_	
	Inspection Strip in Tube Cut Too Short Misread									Power Loss	/Surge	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

October-19-12 2:44:29 PM

Work Order ID: 92040

92040

Parent Item:

646.9501

646 9501 Parent Item Name: 206 Cable Cutter. High

Start Date: 19/10/2012

Required Date: 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

Manufactured

Purchased

No

No

No

Location

110 Each

Loc Qty

1,196.000

Loc Code

DAS 27

308		168
	122452	168
ST291		672
	117423	71
	119075	1
	120308	44
	121011	43
	121243	500
•	121708	13
ST305		356
	123265	356
		110 Each

18.0000

647.1210

MS35842-11

Location	Loc	: Oty
ST438		18
91438		18
	110	Each

Loc Code

Hose Clamp

DAS 27 Location Loc Qty ST290A 123023 8

Loc Code

23023

											DQA:	Date:	<u>, </u>
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPD	ATE			
											QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				ł .	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	- 1	nitial	Actio	n	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
Doc/Data								•					
Equip/Tooling	L												
Operator				İ					•				
Material													
Setup													
Other													,
Process													
Supplier													
Training					ļ								
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng (Sear				General		_			_		_
	L	Bending				Bend		Grain		·	Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped. Burrs					Burrs					Part Lost/M	issing	Wrong Stock Pulled
	Cuffs Contamination						Maintenance Part Moved				-		
	Heat Treat Countersink Mis						Mislabe	eled		Positioned \	Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

October-19-12 2:44:29 PM

Work Order ID: 92040

Parent Item:

646.9501

Parent Item Name: 206 Cable Cutter, High

646 9501

Start Date: 19/10/2012

Required Date: 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-11

Purchased

No

110

Each 646.0000

DAS

Purchased

No

Loc Qty Location 309 100 122441 100 ST292 46 120833 46 ST307 500 123352 500 110 Each

100.0000

Loc Code

MS27039-08-06

DAS 27 9-89

MS27039-08-09

MS27039-08-12

Purchased

No

No

Location Loc Qty Loc Code ST293 100 117065 100

110

51.0000

DAS 27

9-89

Purchased

Location Loc Qty Mezz 11187

51 110 Each

51

Each

131.0000

Loc Code

DAS 27 9-89

Location Loc Qty Mezz 31 1850 31 ST307 100 123352 100 Loc Code

October-19-12 2:44:29 PM

Shop Packet Print

Page 11

										DQA:	Date	
NCR:	Yes / 1	No			WORK ORDER NON-C	100	NFOR	MANCE / UPI	DATE	•		7
										QA Closed:	Date	•
Work Ord	er.				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part I	No				Scrap Machining Smal Use-as-is Thermoforming Finis Work Order Update Large Fab Comp				Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause	Da	te Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling			1									
Operator			1									
Material												
Setup			}	1								
Other												
Process												
Supplier												
Training												
Unapproved			-								L	
					F	AUL	T CATE	GORY				
Landi	ng Gear				General		_					
	Bend	ing		L	Bend	L	Grain			Ovalized	L	Pressure/Forced
	Centi	e Not Conce	entric to	O/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crack	S			Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	ct [Weld
	Crust	ed/Crimped		Burrs	\Box	Instruct	ions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs		•	Contamination		Mainte	nance		Part Moved	_	_	
	Heat	Treat			Countersink		Mislabe	led		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 12

Picklist Print

October-19-12 2:44:29 PM

October-19-12 2:44:29 Pl

Work Order ID: 92040 *92040* Parent Item: 646.9501 *646 9501* Parent Item Name: 206 Cable Cutter, High **Start Date: 19/10/2012** Required Date: 02/11/2012 Start Oty: 1.00 Required Oty: 1.00 MS27039-1-11 Purchased No 110 Each 137.0000 Location Loc Otv Loc Code DAS Mezz. 37 27 9662 37 9-89 ST305 100 123352 100 Purchased No 110 Each 200.0000 DAS 27 Location Loc Qty Loc Code 9-89 ST328 200 123346 200 MS24694-S8 Purchased No 110 Each Screw DAS Location Loc Qty Loc Code 27 ST302 200 9-89 123348 123348 100 123352 100 AN3-10A Purchased No 110 Each 125709 JB Bolt DAS 27 Location Loc Qty Loc Code 9-89 ST351 251 120873 17 122800 234 647.5701 Manufactured No 110 0.0000 Each

Shop Packet Print

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.	Part No. NCR No. Root Des				Rework Scrap Use-as-is Work Order Update	1 1	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved									·		

Landing	Gear	General		_	_	_
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	_
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset	-	
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish	Г	Out of Sequence		
	Wave/Twist in Tube Folio			Outside Dimensions		

FAULT CATEGORY

October-19-12 2:44:29 PM

Work Order ID: 92040		*92040*							·
Parent Item: 646.9501		*646 9501*							
Parent Item Name: 206 Cable Cutter, H	ligh	(1-(1.7.7(1)			9	Start Date: 19/10/	2012 R	equired Dat	e: 02/11/2012
DAS						Start Qty: 1.00	F	Required Qt	y: 1.00
600.0990 27	Purchased	No	110	Each	0.0000		1	_	- 46 4
*600 <u>-0906</u> * **						(**	26215	3,0	DAS
Magnabond 6398 Part A (One 4 oz can) 600.0991	D 1 1	No	110		0.0000				3:86
27	Purchased	NO	110	Each	0.0000	**	¹ –		DAS /
*60000994 9-89 Magnabond 6398 Part B (One 4 oz can)							126215	JB	
600.1012	Purchased	No	110	Each	0.0000	ا (مر	1	·	4
600-1-01-9 DAS 27						**	12624	7 28	13-08-28
Sealant (One 6 oz Semkit) 9-89							1000		DAS

												DQA:	Da	te:	
NCR:	⁄es	/ No				WORK ORDER NON-	COI	NFORM	/ANCE / UPI	DATE		-		•	
											Q	A Closed:	Da	te:	
Work Orde	er:					DISPOSITION				AGAINST DE	PΑ	RTMENT/	PROCESS		,
Part i	-					Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	Water Jet Prod. Eng. Coor Rec/Store/Packaging				Engineering Quality Other
NCR I	No.					Work Order Update	1		Large Fab	Composite		nee, stor	Supplier		
Root					Descri	ption of work order update		Initial	Act	ion		Sign &			-
Cause		Date	Step	Qty	(or Non-conformance	Ct	ief Eng	Descr	ription		Date	Verificatio	n	QC Inspector
Doc/Data								•							
Equip/Tooling											1				
Operator															
Material	Ш														
Setup															
Other															
Process							1								
Supplier															
Training															
Unapproved															
							AUI	T CATE	GORY						
Landi	ng G	iear				General		_			_				-
	Ш	Bending				Bend		Grain			Jo	valized			Pressure/Forced
	Centre Not Concentric to O/S BOM/Route							Hardwa	re		Jo	ver/Under	tolerance		Temperature/Cure
	Cracks Broken/Damaged					Broken/Damaged		Inspecti	on Incomplete		P	art Incorrec	:t		Weld
	Crushed/Crimped. Burrs							Instruct	ions Incomplete/I	Unclear	P	art Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs Contamination					Contamination	Maintenance Part Moved				art Moved			-	
	Heat Treat Countersink						Mislabeled			Positioned Wrong					
	Inspection Strip in Tube Cut Too Short					Cut Too Short		Misread	l	Power Loss/Surge Other					Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 92040 October-19-12 2:44:25 PM 646.9501 Item ID: **Revision ID:** 206 Cable Cutter. High Item Name: 19/10/2012 Start Qty: 1.00 **Start Date:** Req'd Qty: 1.00 **Required Date:** 02/11/2012 *1 Reference: Process Plan: ML5 Date: \7-10 Approvals: QC: Date: Operation Sequence ID/ Description Work Center ID **Revision Nbr** Draw Nbr

N/C

DOCUMENT CONTROL

Pick Kit

Memo

QC4-100% Inspect kits for completeness

0.00

0.00

646.9500

100

Document Control

110

120

Quality Control

Packaging

Packaging

100

110

120

	97(14(1						
	Accept		*N900040100*)* Setu	etup Start Stop	1/1/2 1
						зюр	*NS2*
ty: 1.00	*1*		Cust Item II) :			
Qty: 1.00	*1*		Customer:				
					Rui	Start	*NR1*
.5	Date: 12-10-19 Tooling:		Date:			Stop	
	Date:	SPC (Y/N):	Da	te:		ə.cə p	*NR2*
on tion		Set Up/ Run Hours	Tool ID	Tool # Plan Code			Reject Insp. Number Stamp
•	1.B				==	- 12	08.28
ENT CONTRO) T	0.00			MCJ) \2	
Memo		0.00					
Photocopy b	bluefile & type labels per	PPP 646.9501		-			
		0.00					
Memo		0.00				•	

92040

Linda Lacelle

From:

Dave Barker

Sent:

October-24-13 11:40 AM

To:

Linda Lacelle

Cc:

David Duval; Jean-Luc Menard

Subject:

RE: 647.5701

647.5701 is an optional kit. It is on the drawing as a reference only. If the customer wants the 647.5701 it should be purchased separately. It is not part of the regular 646.9501 kit.

Thanks,

Dave

From: Linda Lacelle

Sent: Thursday, October 24, 2013 8:14 AM

To: Dave Barker

Cc: David Duval; Jean-Luc Menard

Subject: 647.5701 Importance: High

Can someone tell me if these go into the 646.9501 kits or not pls????????

Linda Lacelle Production manager Dart Aerospace